



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3910-3
Job Sheet 186317



Part No: D3910-3

Job Qty: 24 ea

Part Name: Crosstube Lug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/14/18

Job Tracking No:

Due Date: ~~11/28/18~~

12/20/2018

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E SHEETS 1,3 IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD IPP REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD IPP REV:C 18.02.02 REMOVE FINISH DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Purchasing	24 pcs		11/28/18			ATG001-VC	5	NOV 27 2018
120	Packaging	24 pcs		11/28/18	0.00	0.00	Packaging2		NOV 27 2018
130	QC	24 pcs		11/28/18	0.00	0.00	QC6		NOV 28 2018
180	Packaging	24 pcs		11/28/18	0.00	0.00	Packaging3-2		DEC 06 2018
190	QC21-SA	24 Ea		11/28/18	0.00	0.00	QC21		DEC 06 2018

Part Op 110 - ISSUE PO TO METEC, NOTE ALODINE AND PAINT AS PER QSI 005

Descriptions: 120 - Ensure C of C is attach

135 - Alodine

041476

x 24

Nov 15. 2018

DEC 06 2018

138 - Powdercoat

Job BOM

8 FEB 18-11-29.

Part / Item	Component Name	Quantity	Operation	Container
D2423	Lug Extrusion	3 ft (.125 ea)	110-Purchasing	5131630
D3910-3P	Crosstube Lug	24 pcs (1 ea)	110-Purchasing	5131629

M138951 START: 11:15 TEMP: 320° FINISH: 11:45

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Purchasing	D2423	3	240	0
	D3910-3P	24	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Crosstube Lug	4.450Inches ± 0.030	4.480 4.420		
2	Crosstube Lug	1.380Inches ± 0.030	1.410 1.350		
3	Crosstube Lug	0.080Inches ± 0.020	0.100 0.060	Radius	
4	Crosstube Lug	0.270Inches ± 0.030	0.300 0.240	reference	
5	Crosstube Lug	0.310Inches ± 0.030	0.340 0.280		
6	Crosstube Lug	0.735Inches ± 0.010	0.745 0.725	reference	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																											
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OTHER : ☐				Container No: S131631 Part: D3910-3 Job No: 186317 Serial No/Batch: S131631 Revision: Inspector: Exp Date: Instructions: Various STCs 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com																																															

7	Crosstube Lug	1.200Inches $\pm$ 0.030	1.230 1.170	Radius
8	Crosstube Lug	3.700Inches $\pm$ 0.010	3.710 3.690	
9	Crosstube Lug	0.375Inches $\pm$ 0.010	0.385 0.365	
10	Crosstube Lug	0.625Inches $\pm$ 0.010	0.635 0.615	
11	Crosstube Lug	0.375Inches $\pm$ 0.010	0.385 0.365	
12	Crosstube Lug	0.340Inches $\pm$ 0.030	0.370 0.310	Radius
13	Crosstube Lug	0.257Inches $\begin{matrix} + 0.006 \\ - 0.001 \end{matrix}$	0.263 0.256	Diameter
14	Crosstube Lug	0.100Inches $\pm$ 0.010	0.110 0.090	
15	Crosstube Lug	45.000Degrees $\pm$ 0.500	45.500 44.500	angle
16	Crosstube Lug	1.410Inches $\pm$ 0.030	1.440 1.380	Reference

Plex 11/14/18 8:54 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

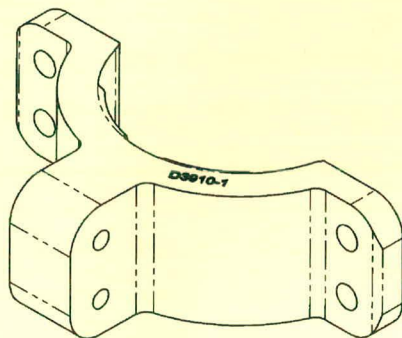


WORK ORDER NON-CONFORMANCE / UPDATE

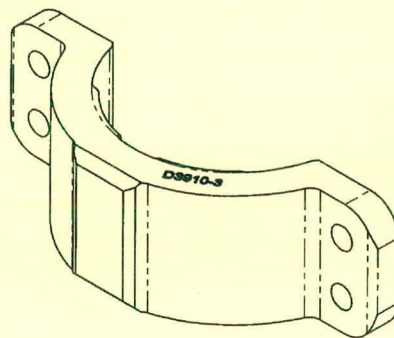
QA Closed: _____ Date: _____

Work Order update only ☐

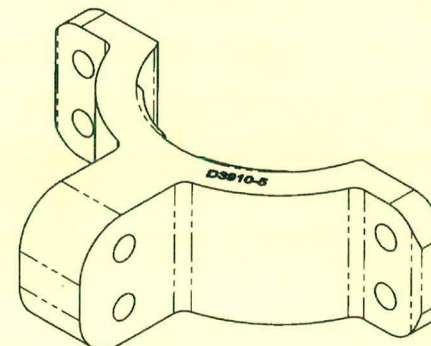
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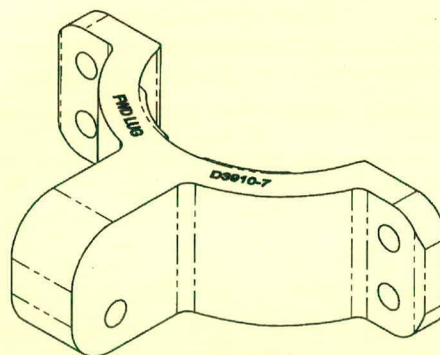
D3910-1 X-TUBE LUG



D3910-3 X-TUBE LUG



D3910-5 X-TUBE LUG



D3910-7 X-TUBE LUG

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 $\pm$ 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 $\pm$ 0.005
- 7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs
-5: 0.36 lbs
-7: 0.37 lbs
- 8) IDENTIFICATION: ENGRAVE "FWD LUG" TO A DEPTH OF 0.010 $\pm$ 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 $\pm$ 0.005

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 186317 M.C.S.
18-11-14

RELEASED

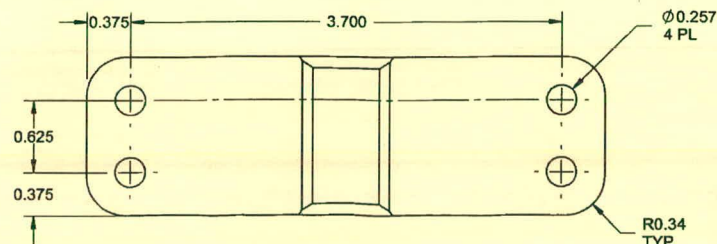
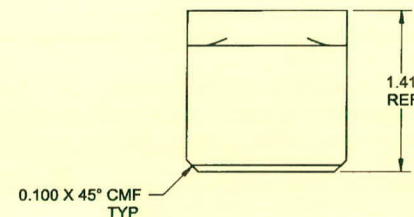
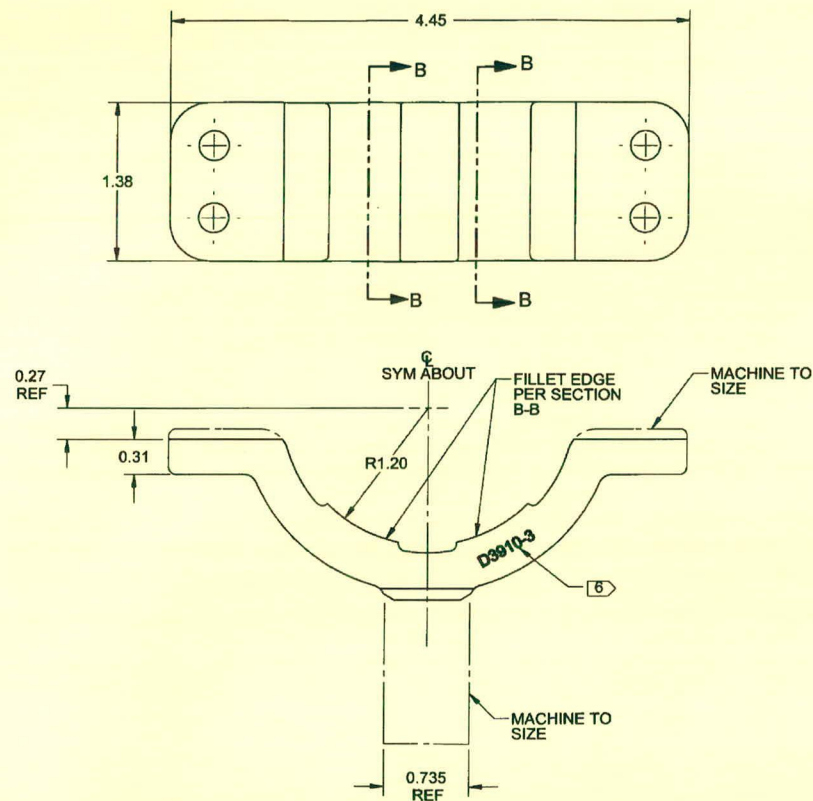
2014 JUN 05 CP
ECN 14-572

E	ADD -7 PER NCR14-3871	AJS	14.05.16
D	CHANGED FASTENER HOLES IN -5 FOR 1/4" HARDWARE. REASON: EASE OF INSTALLATION.	AJS	13.08.14
C	ADD -5.	AJS	13.08.08
B	Ø0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-D390-607-2	JPH	10.03.16
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AJS	DRAWING NO.	REV. E
MFG. APPR.	AJS	D3910	SHEET 1 OF 5
APPROVED	AJS	TITLE	SCALE
DE APPR.	AJS	X-TUBE LUG (350)	NTS
DATE	14.05.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

SECTION B-B



ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL



D3910-3 X-TUBE LUG

RELEASED
2014 JUN 05

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D3910	REV. E
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 5	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	X-TUBE LUG (350)	NTS
DATE	14.05.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041746**

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041746

PO Date: 11/15/18

Due Date: 12/20/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	186313	D2230-1P			Lug As Per Dwg D2230 Rev. G Alodine and Paint as per QSI 005	Firmed	-	12/20/18	200 pcs	0 pcs	200 pcs	\$17.40/pcs	\$3,480.00
Line Item Note SHIP ASAP NO PAINT REQUIRE													
2	186314	D2230-3P			Lug As Per Dwg D2230 Rev. G Alodine and Paint as per QSI005	Firmed	-	12/20/18	200 pcs	0 pcs	200 pcs	\$14.90/pcs	\$2,980.00
Line Item Note SHIP ASAP NO PAINT REQUIRE													
3	186316	D3910-1P			Crosstube Lug : Various STC's As Per Dwg D3910 Rev. E Alodine and Paint as pe QSI 005	Firmed	-	12/20/18	20 pcs	0 pcs	20 pcs	\$17.40/pcs	\$348.00
Line Item Note PLEASE SUPPLY PAINTED													



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041746**

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	186317	D3910-3P			Crosstube Lug : Various STC's As Per Dwg D3910 Rev. E Alodine and Paint as Per QSI 005	Firmed	-	12/20/18	24 pcs	0 pcs	24 pcs	\$17.40/pcs	\$417.60
24 X NOV 27 2018 DAS 68 9-89													
Line Item Note SHIP ASAP NO PAINT REQUIRE													
5	186315	D3338-1P			Mounting Lug : Various STC's receive pcs REV A	Firmed	-	12/20/18	40 pcs	0 pcs	40 pcs	\$20.60/pcs	\$824.00
Line Item Note PLEASE SUPPLY PAINTED													
												Grand Total:	\$8,049.60

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

Plex 11/19/18 11:56 AM dart.Lussier.Patrick

•
•
•

246
80
18.0

Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Shipment No: 24273
Shipment Date: 22-Nov-2018
Ship Via: Pick up at METEC
Order Number: 3192
Order Date: 11/16/18

Customer Code: DART
Phone: (613) 632-9577
PO Number: PO041746
Terms: Net 60 Days

Not painted as per Patrick Lussier

Quantity								Job
Item	Open	Shipped	B/O	Canceled	Unit	Description	Revision	Number
4	24	24	0	0	EA	DART-D3910-3P Crosstube Lug NOT PAINTED	E	3192-04

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Received In Good Order By



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev.#	Material Batch #	Paint Batch #	P.O. Number
24	D3910-3	Cross Tube Lug	E	B101186	Unpainted	41746

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Heather Nixon

Vankleek Hill, November 22, 2018

DAS
68
9-89

RECEIVED

1958

OFFICE OF THE ATTORNEY GENERAL

STATE OF NEW YORK

IN SENATE

REPORT OF THE COMMISSIONER OF THE DEPARTMENT OF SOCIAL SERVICES

FOR THE YEAR ENDING DECEMBER 31, 1957

0-88-0
82
DUE